

19-7780. P.T.O last page



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2432
Job Sheet 202736



Part No: D2432

Job Qty: 24 pcs

Part Name: Bearpaw 19" X 24"

23 pcs B.e



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 12/6/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	24 pcs		12/6/19	0.00	0.00	Purchasing - 1		NOV 11 2019
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	24 pcs		12/6/19	0.00	0.00	Packaging 2 - 1 - B4B		NOV 11 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230525



Part: D2432

Job No: 202736

Serial No/Batch: S230525

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
110 QC 6	24 pcs	12/6/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130 HAAS 4 Axis - B4B	24 pcs	12/6/19	1.00 30.04	HAAS - 1 - B4B	
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	
				HAAS - 4 - B4B	
140 QC 2	24 pcs	12/6/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	

				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DIP 19-11-16
				QC 2 - 69	
150 QC 8	24 pcs	12/6/19	0.00 0.00	QC 8 - 12	C/S
				QC 8 - 14	19/11/20
				QC 8 - 17	9-19
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
160 Packaging 3-1 - Stock - B4B	24 pcs	12/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	24 pcs	12/6/19	0.00	0.00	QC 21 - SA - 21	DAS 21
						NOV 20 2019
						QC 21 - SA - 70
						QC 21 - SA - 53

Part Op 90 - 1-Issue PO: 44981 2-Cut blanks as per D2432_NEST7 file.
 Descriptions: 100 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)
 110 - (QC6- All purchased or subcontracted products)
 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Debur
 140 - (QC2- Inspect parts off machine FAI/FAIB)
 150 - (QC8- Inspect parts - second check)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2432P	Bearpaw 19" X 24"	24 Ea (1 ea)	90-Purchasing	5230582
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	88.8000 sf (3.7 ea)	90-Purchasing	5228711

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2432P	24	0	0
	MUHMWB10	89	666	0
Part Specifications				
Specifications could not be found.				

Plex 11/1/19 10:52 AM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044981



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044981
PO Date: 11/1/19
Due Date: 11/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com
Via: Ground
Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202736	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X74	-	11/15/19	24 Ea	0 Ea DAS 81 9-89	24 Ea	\$35.26/Ea	\$846.24 NOV 1 1 2019
2	202735	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X74	-	11/18/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24 NOV 1 1 2019
3	202734	D4355-1P	D4355 Rev B			Bearpaw - cut blanks as per D4355-1 file	Firmed X10	-	11/15/19	6 Ea	0 Ea	6 Ea	\$44.88/Ea	\$269.28 NOV 1 1 2019
4	202733	D4930-3P	D4930 Rev B			Bearpaw - cut blanks as per D4930-3 file	Firmed X10	-	11/15/19	8 Ea	0 Ea	8 Ea	\$25.61/Ea	\$204.88 NOV 1 1 2019
5	202732	D4930-1P	D4930 Rev B			Bearpaw - cut blanks as per D4930-1 file	Firmed X4	-	11/15/19	4 Ea	0 Ea	4 Ea	\$23.09/Ea	\$92.36 NOV 1 1 2019
6	202731	D5377-1P	D5377 Rev A			Bearpaw - cut blanks as per D5377-1 file	Firmed X8	-	11/15/19	8 Ea	0 Ea	8 Ea	\$48.89/Ea	\$391.12 NOV 1 1 2019
7	202742	D4353-041P	D4353 Rev B			Bearpaw - cut blanks as per D4353-041 file	Firmed X10	-	11/15/19	10 Ea	0 Ea	10 Ea	\$42.68/Ea	\$426.80 NOV 1 1 2019



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PURCHASE ORDER

POHB044981



Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	202741	D2521P	D2521 Rev A			Individual Bearpaw - cut blanks as per D2521_BLANK file	Firmed X14	-	11/15/19	14 Ea	0 Ea	14 Ea	\$57.77/Ea	\$808.78
9	202740	D4297-1P	D4297 Rev C			Bearpaw - cut blank as per D4297-1 file	Firmed X6	-	11/15/19	6 Ea	0 Ea	6 Ea	\$33.18/Ea	\$199.08
10	202737	D2435P	D2435 Rev E1			Bearpaw - cut blank as per D2435 file	Firmed X12	-	11/15/19	12 Ea	0 Ea	12 Ea	\$26.45/Ea	\$317.40
													Grand Total:	\$4,402.18

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 DOCUMENT SPECIAL REQUIREMENTS
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 11/6/19 8:34 AM Dart.Guerin.Kimberley

A.D.S.

Acier Duval Steel

Fabrication shop: aluminum and stainless steel
plate cutting, bending, rolling and punching services.

Atelier de fabrication: aluminium et acier inoxydable
Service de coupage, pliage, roulage et poinçonnage.

1-866-831-5722

T: 613-673-4574

info@adsindustries.com

5888 County Rd. 17

Plantagenet, ON.

K0B 1L0

Packing Slip:

8123

Nov 07, 2019

1 of 1

Sold to:	Ship to:
Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: POHB044981	Sold By:
Shipped By:	Ship date:
Tracking No:	

Item No	Quantity	Description
Waterjet cutting	24	Job: 202736 part: D2432P drawing D2432 rev H, Bear paw 19" x 24"
Waterjet cutting	24	Job 202735 part D2432P Drawing D2432 RevH, Bearpaw 19" x 24"
Waterjet cutting	6	Job 202734 part D4355-1P Drawing D4355 RevB, Bearpaw
Waterjet cutting	8	Job 202733 part D4930-3P Drawing D4930 RevB Bearpaw
Waterjet cutting	4	Job 202732 part D4930-1P Drawing D4930 RevB Bearpaw
Waterjet cutting	8	Job 202731 part D5377-1P Drawing D5377.Rev A Bearpaw
Waterjet cutting	10	Job 202742 part D4353-041P Drawing D4353 Rev B Bearpaw
Waterjet cutting	14	Job 202741 part D2521P Drawing D2521 RevA Individual Bearpaw
Waterjet cutting	6	Job 202740 part D4297-1P Drawing D4297 Rev C Bearpaw
Waterjet cutting	12	Job 202737 part D2435P Drawing D2435 Rev E1 Bearpaw
Work order #2019-039 Customer material: UHMW 1" black 45" 120" Tivar		
RECEIVED NOV 08 2019 DART AEROSPACE LTD.		
Comment: ADS industries = Facebook & Instagram		

Acier Duval Steel div. JD Welding Inc.

5888 County Road 17, Plantagenet ON. K0B1L0

Tel: 613-673-4574 ~~ toll free\ sans frais 1-866-831-5722

info@adsindustries.com www.adsindustries.com

Certificate of Conformance (CoC)

Customer Name	Dart Aerospace
P.O. Number	POHB044981
Part Number	D2432P (Job : 202736)
Drawing Number	D2432 Rev H
Material thickness	1"
Quantity	24
Invoice \ Packing slip #	8123

DAS
81
9-89

DAS
8
9-89

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawing and document

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

The Quantity in the P.O

The Drawing send to the administration

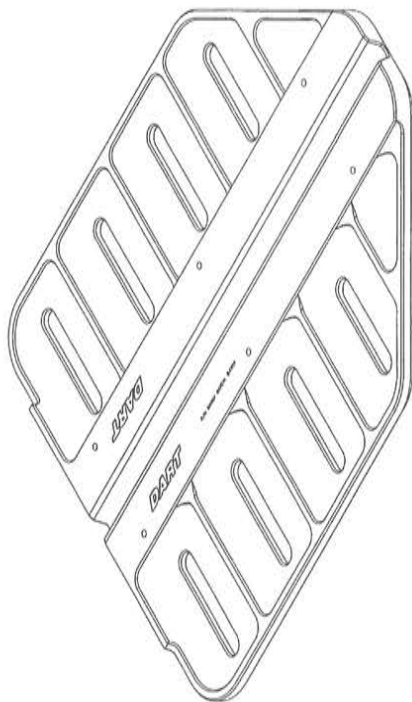
And other document send in regard to the pieces

*(Acknowledge by marking the boxes)

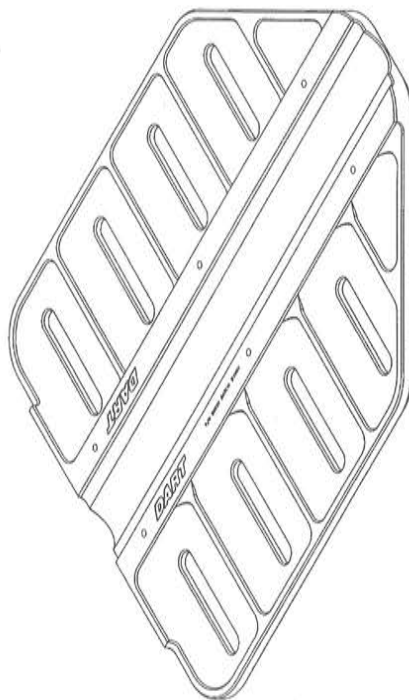
✓
✓
✓

	Quality Management	November 7 2019
Signature	Title	Date

This certifies the parts / items / material identified above conform to all applicable drawing and/or specification as evidenced by report or other documentation on file and all other purchase order and



D2432-3 BEARPAW



D2432F BEARPAW

RELEASED
2012-10-16

REV	DESCRIPTION	BY	DATE
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT. REMOVED D2432B, ADD D2432-3. ADDED DIMENSION 7.52 (D1-E2)	AP	12.05.02
F	CHANGE C'BORE. ADD B AND F PIN	-	98.05.12
E	CHANGE C'BORE DEPTH. BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
DESIGN	LE	DATE	
DRAWN	AP		
CHECKED	AP		
MFG APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	12.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2432**
SHEET 1 OF 3

TITLE **BEARPAW**
SCALE **NTS**

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DART AEROSPACE LTD		Work Order: 202736
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060	✓		Ver.	
B	0.200	+/-0.030	0.200	✓		Ver.	
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓		Ver.	
D	R0.250	+/-0.030	0.250	✓		R. G.	
E	0.250	+/-0.010	0.250	✓		Ver.	
F	0.625	+/-0.030	0.626	✓		Ver.	
G	0.375	+0.030/-0.010	0.378	✓		Ver.	
H	0.950	+/-0.030	0.958	✓		Ver.	
I	19.000	+/-0.030	19.000	✓		Tape	
J	Ø0.260	+0.005/-0.000	Ø0.26	✓		G.P.	
K	Ø0.93	+/-0.030	Ø0.93	✓		Ver.	
L	0.30	+0.030/-0.000	0.315	✓		Ver.	
M	23.750	+/-0.030	23.750	✓		Ver.	
N	2.000	+/-0.030	2.018	✓		Ver.	
O	0.38	+/-0.030	0.378	✓		Ver.	
P							
Q							
R							
S							
T							
U							
V							

Measured by: DAS 73 9-89	Audited by: 14 JAL	Preliminary Approval:
Date: 19-11-16	Date: 19/11/20	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

Entered: 26 Date: Dec 30/19
 NCR No. 19-7780



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>202736</u> Part No. <u>D2432</u>		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Engineering ☐ Machining ☒ Water Jet ☐ Large Fab ☐ Supplier ☐ Quality ☐				MRB (QSI042) <u>D 19-11-13</u>	
Date: <u>19-11-18</u> Sequence #: <u>130</u>		QTY Affected: <u>1</u>		Completed By <u>DIP 19-11-18</u> Lead hand / Supervisor <u>30 19-11-18</u> QC / QA Coordinator <u>D 19-11-13</u>			
Description Work Order Deviation <u>Loaded wrong Prog #, and damaged one of the 0.261ø holes</u>		Disposition <u>Scrap. and destroy.</u>					
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Other/Details:							